

Work Order ID 59372

Page 1

Wednesday, June 02, 2010 1:19:55 PM

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: HDate: 10-6-02 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

100



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

*Siobhán***B59372**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

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Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750. Deburr.

4- Drill fwd step holes using DT9616. Ensure proper positioning.

5-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

6- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

7-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

8-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

9-Open up holes of Detail J to 0.297" (total of 2 holes per side)

10-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

Batch: M114242

BE 10/06/10

W/O:		WORK ORDER CHANGES					
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Tool ID

Tool #

Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

11-Grind welds flush as per Dwg D2750

12- scribe batch #.

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00



BE 10/06/10 AWM 10-06-10

S 10/06/14

S 10/06/14

70

W/O:		WORK ORDER CHANGES						
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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP 10-6-15

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ Sikaflex-291 batch: 610519 ☐☐
exp. date: 10/11/16

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod batch: M114242

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

M 10/6/15

BE 10/06/16
BE 10/06/16

DP 10-6-16

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/10

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10



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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 Bl 10-7-8.

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 11:15

OVEN TEMPERATURE: 320P

FINISH TIME: 11:45

1 Bl 10-7-8.

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Inspect for foreign object per QSI 024

=) 10/07/13

1 0

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Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

Install inserts as per dwg D2750

0.00

0.00

=) 24 10/07/13

1

0

230



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: N/A

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: 1113519

EXP DATE: 10/11

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 1114189

5-Coat all exposed fasteners with "LPS Procyon"
batch: 104251

0.00

0.00

=) 24 10/07/14

1

0

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

0.00

QC

Quality Control

Memo

8.10.10/14

HL

250

Pick Kit

0.00

0.00

Packaging

Packaging

Memo

6.2.10/15 (1)

260

QC4- 100% Inspect kits for completeness

0.00

0.00

QC

Quality Control

Memo

8.10.10/14

HL

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

6/2/10
1007-14
1007-14
①

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

7,062.000

38

38



Insert

Location

Loc Qty

Loc Code

PK011

7062

110768

7062

AN3C5A

Purchased

No

230

Each

923.0000

34

34



Bolt

Location

Loc Qty

Loc Code

ST350

825

114330

125

114523

200

114808

500

ST351

98

113121

10

114108

45

114181

43

AN3C6A

Purchased

No

230

Each

565.0000

4

4



BOLT

Location

Loc Qty

Loc Code

ST351

565

111982

565

x38 AD 10/07/13

1115015

x34 AD 10/07/13

x4 AD 10/07/13

W/O:		WORK ORDER CHANGES					
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 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased No

230

Each

151.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

149

111649

2

114455

47

114653

50

114784

50

AN8C35A

Purchased No

230

Each

56.0000

1



BOLT

Location

Loc Qty

Loc Code

FP

6

110847

6

ST346

50

114442

50

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38



washer

Y m 115 000



x1 10/07/13

x38 10/07/13

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Shop Packet Print

Page 2

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 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No 230 Each 106.0000 1 1



WASHER

Location

Loc Qty

Loc Code

ST348

106

110584

100

111424

6

Manufactured No

230 Each

146.0000

8

8

D2745



Bushing

Location

Loc Qty

Loc Code

ST023

146

52311

69

57914

77

Manufactured No

230 Each

19.0000

1

1

D3488-042



Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

19

53918

19

Manufactured No

230 Each

94.0000

8

8

D3492-041



Plug Assembly

Location

Loc Qty

Loc Code

FP013

94

57915

30

58180

60

59189

4

B59420

VS 10/07/13

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Shop Packet Print

Page 3

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 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-043



Manufactured No

230

Each

57.0000

8

8

Plug Assembly

Location

Loc Qty

Loc Code

FP

2

54682

2

B359421

FP013

55

57916

51

50190

4

Manufactured No

230

Each

13.0000

1

1

D3535-25



Wearshoe

Location

Loc Qty

Loc Code

FP18

13

57943

13

B359150

Manufactured No

230

Each

32.0000

1

1

D3536-25



Gasket

Location

Loc Qty

Loc Code

FP12

32

57944

6

58820

26

v1 10/02/13

10/02/13

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 11.0000 3 3



Wearpad

Location

Loc Qty

Loc Code

FP 1
 55465 1
 FP17 10
 57713 10

B59513

✓ 3 10/07/13

D3631-1 Manufactured No 230 Each 206.0000 8 8



Washer

Location

Loc Qty

Loc Code

ST076 206
 52693 206

B51388

✓ 8 10/07/13

D3672-1 Manufactured No 230 Each 1,367.000 4 4



Phenolic Washer

Location

Loc Qty

Loc Code

ST077 1367
 51674 367
 52505 1000

✓ 4 10/07/13

D3791-1 Manufactured No 230 Each 5.0000 1 1



Wearplate

Location

Loc Qty

Loc Code

FP17 5
 56299 5

B58906

✓ 1 10/07/13

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Page 5

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-636-012

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Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No 230 Each 10.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP18 10
 56300 1
 57945 9

B59151

x1 10107113

D3793-3 Manufactured No 230 Each 27.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP18 16
 59152 16
 FP19 11
 57947 11

x1 10107113

D3794-1 Manufactured No 230 Each 32.0000 1 1



Gasket

Location

Loc Qty

Loc Code

FP010 26
 57942 26
 FP014 6
 57537 6

B59627 x1 10107113

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Page 6

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

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 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-3



Gasket

Manufactured No 230 Each 14.0000 1 1

MS21043-6



NUT

Purchased No 230 Each 826.0000 4 4

Location

Loc Qty

Loc Code

FP18

14

B39153

56066

14

Y1 10/07/13

Location

Loc Qty

Loc Code

ST301

826

112314

826

X4 10/07/13

MS21083C8



NUT

Purchased No 230 Each 41.0000 1 1

Location

Loc Qty

Loc Code

ST303

41

113845

11

111934

114523

30

Y1 10/07/13

NAS1611-010



O-RING

Purchased No 230 Each 302.0000 8 8

Location

Loc Qty

Loc Code

FP

302

110715

100

110915

202

PTO =)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/13	230	Replace NAS1611-010" O-Rings" with Q2594-3/ B59358	JA	10/07/13	1	[Signature]	[Signature]

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased No

230

Each

219.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

219

181

38

N4451
Q4496

Purchased No

250

Each

111.0000

2

2

AN8C21A



BOLT

Location

Loc Qty

Loc Code

ST345

111

111605

21

113558

50

114653

40

Purchased No

250

Each

106.0000

1

2

AN960C816L



WASHER

Location

Loc Qty

Loc Code

ST348

106

110584

100

111424

6

Manufactured No

250

Each

27.0000

1

1

D2741



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

27

55905

27

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X6 41 10/07/13
X2 41 10/09/13

10-7-78

2

10-7-98

2

10-7-9 SP

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 9

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

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 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3493-1



Washer

Manufactured No 250 Each 33.0000 2



B59127 10-7-98

Location Loc Qty Loc Code

ST065 33
 57825 33

D3532-1



Spacer

Manufactured No 250 Each 25.0000 2



B59426 10-7-98

Location Loc Qty Loc Code

ST068 25
 52321 25

D3672-13



Phenolic Washer

Purchased No 250 Each 894.0000 2



10-7-98

Location Loc Qty Loc Code

ST077 894
 54363 894

MS21083C8



NUT

Purchased No 250 Each 41.0000 1



M114934 10-7-98

Location Loc Qty Loc Code

ST303 41
 113845 11
 114523 30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 10

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

13.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

13

58903

13

D2744

Manufactured No

110

Each

13.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

13

51922

13

D2739

Manufactured No

160

Each

7.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

7

57948

1

58213

1

58904

5

D2743

Manufactured No

160

Each

57.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

57

50281

10

52310

24

57953

23

B 59111

x 8

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BE 10/06/10

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 11

Work Order ID: 59372

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No 160 Each 66.0000 4 4



Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	66	
57918	6	
59229	60	

D3490-1 Manufactured No 160 Each 56.0000 4 4



Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	56	
59228	56	

4 BE 10/06/16

4 BE 10/06/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
✓								

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59372

BS 10-6-02 RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT	DART AEROSPACE USA, INC.	
DRAWN	PORT	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

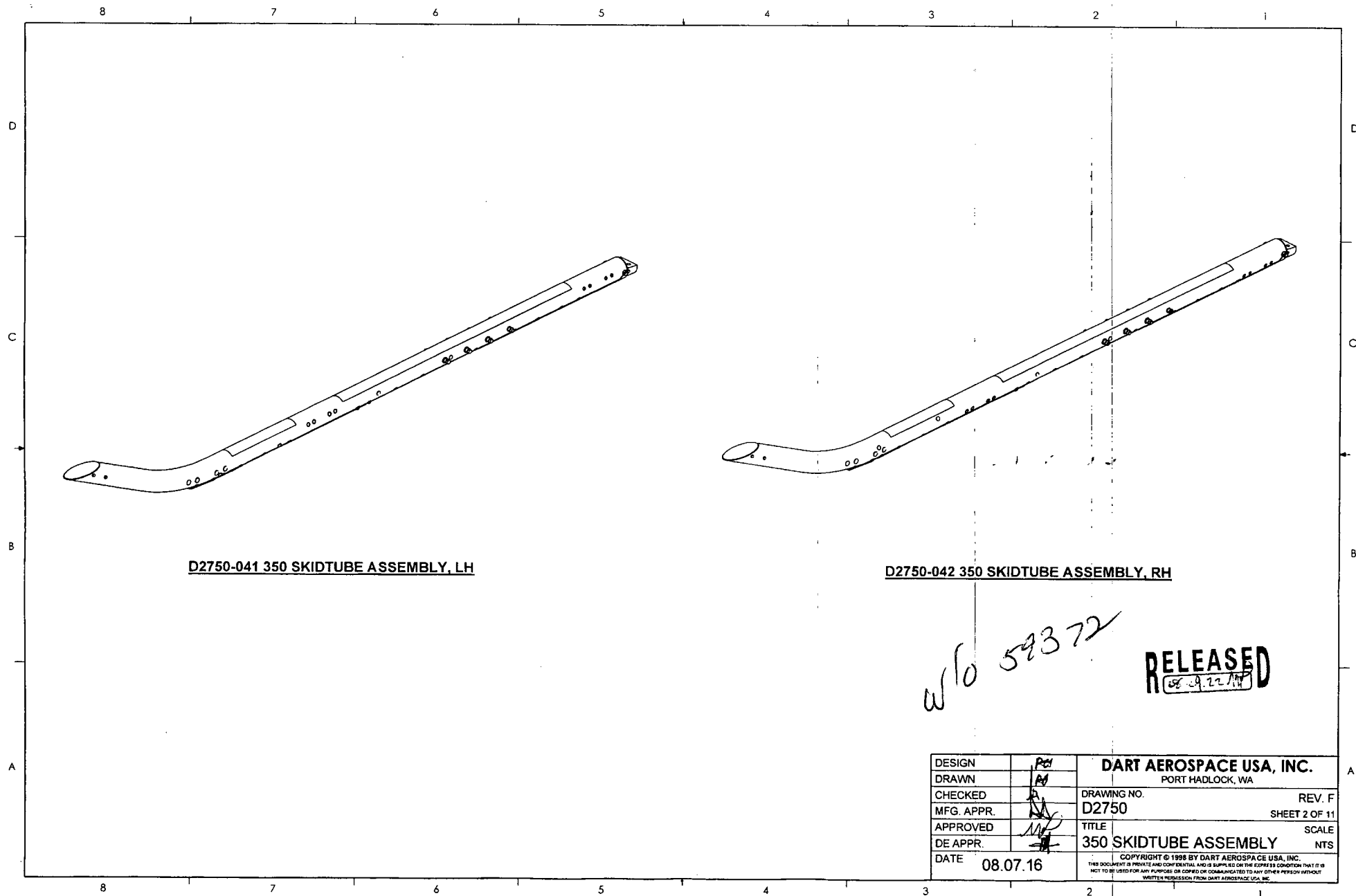
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

w/lo 59372

RELEASED
65-9-22/100

DESIGN	MD	DART AEROSPACE USA, INC.	
DRAWN	MD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

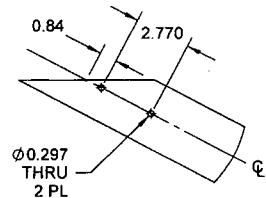
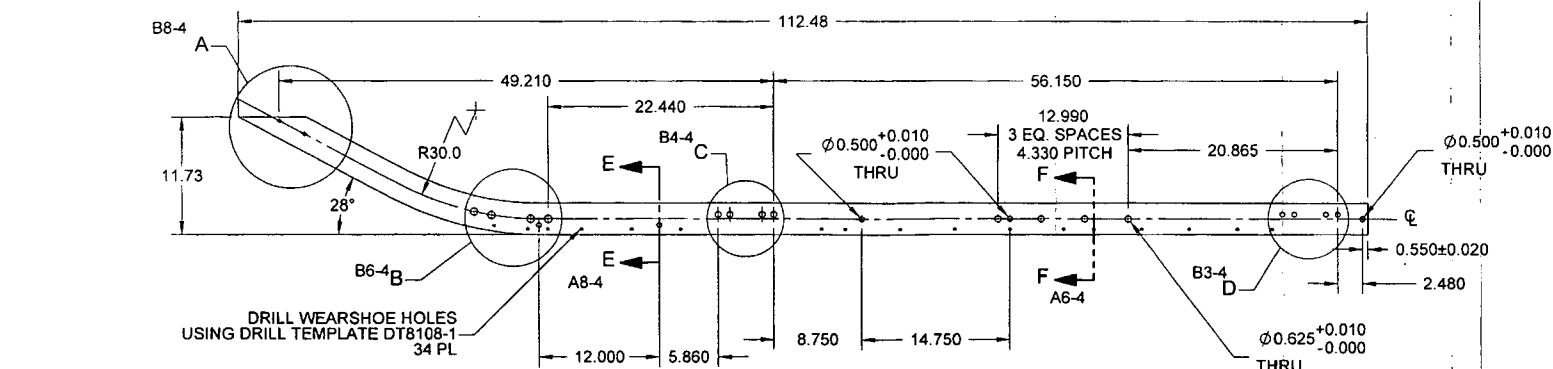
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

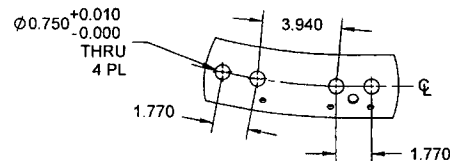
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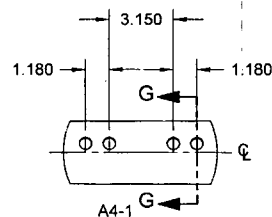
D2750-1 LH SKIDTUBE



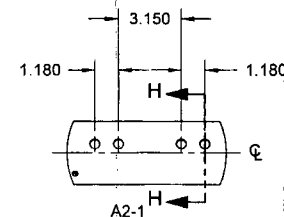
DETAIL A
SCALE 2X



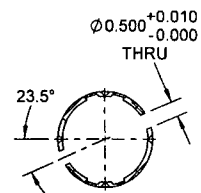
DETAIL B
SCALE 2X



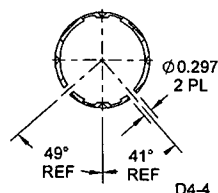
DETAIL C
SCALE 2X



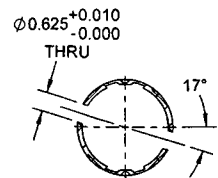
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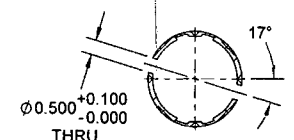
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	IPM
DRAWN	PP
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 4 OF 11
SCALE NTS	
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Dart Aerospace Ltd

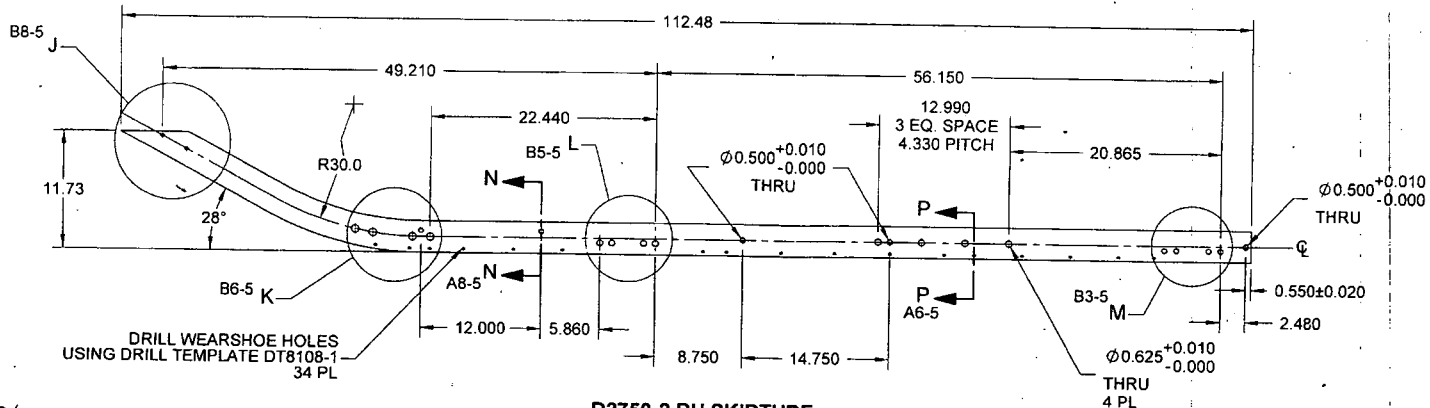
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

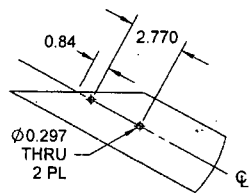
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

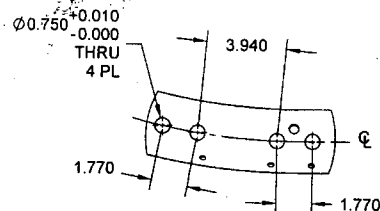
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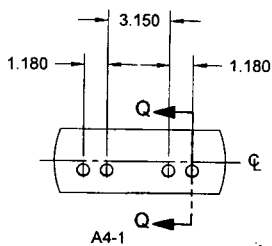
D2750-2 RH SKIDTUBE



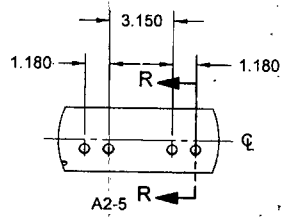
DETAIL J
SCALE 2X



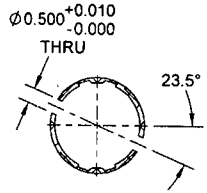
DETAIL K
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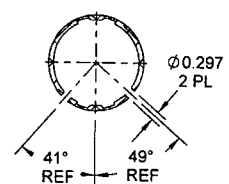
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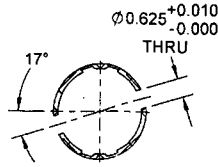
DETAIL M
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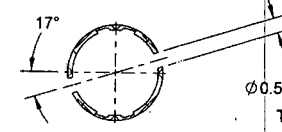
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	REV	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	REV		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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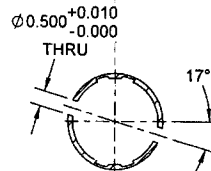
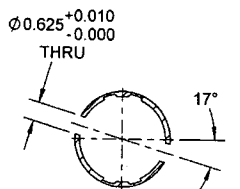
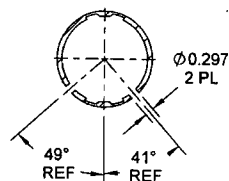
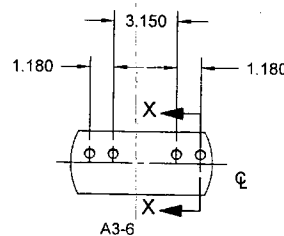
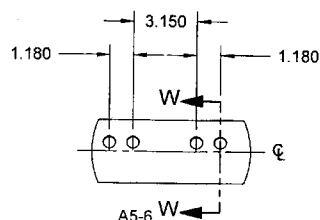
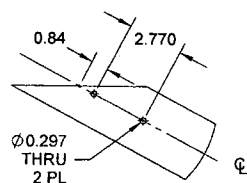
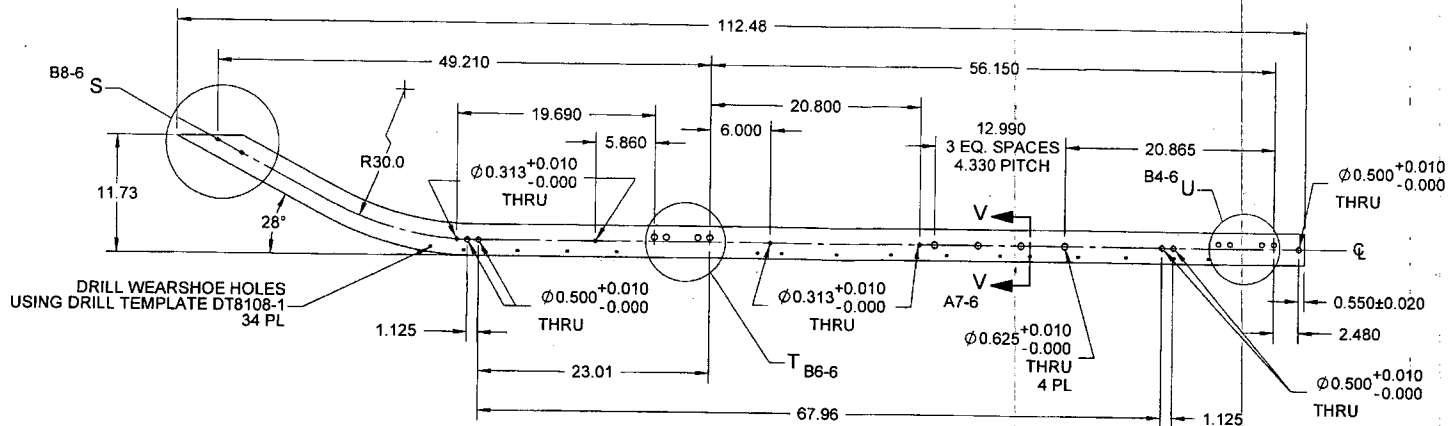
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2

1



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08-22-11

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		SHEET 6 OF 11	
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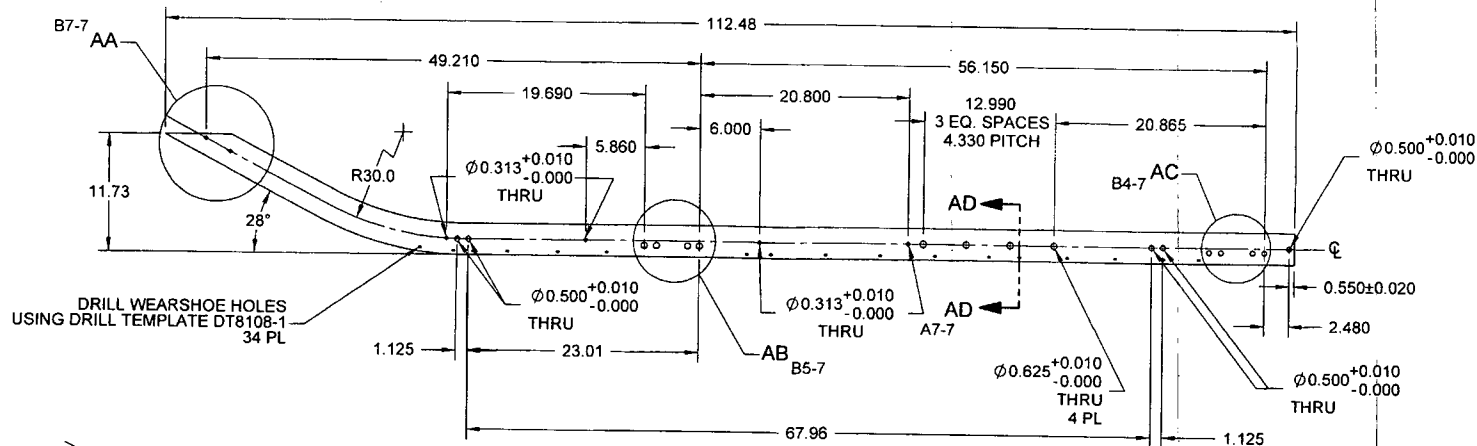
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

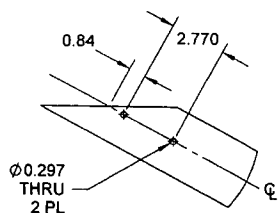
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

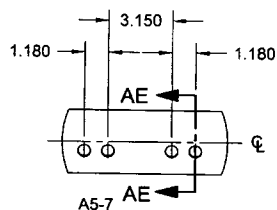
NOTE: Date & initial all entries



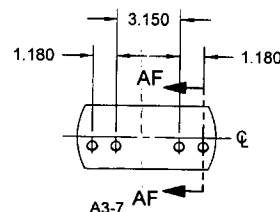
D2750-4 RH SKIDTUBE



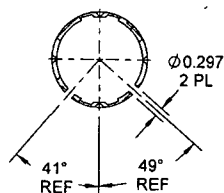
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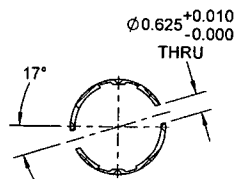
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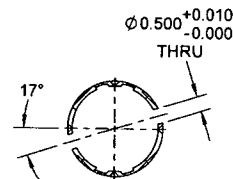
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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06-09-2010

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO. D2750	REV. F
MFG. APPR.	PA		SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	NTS	

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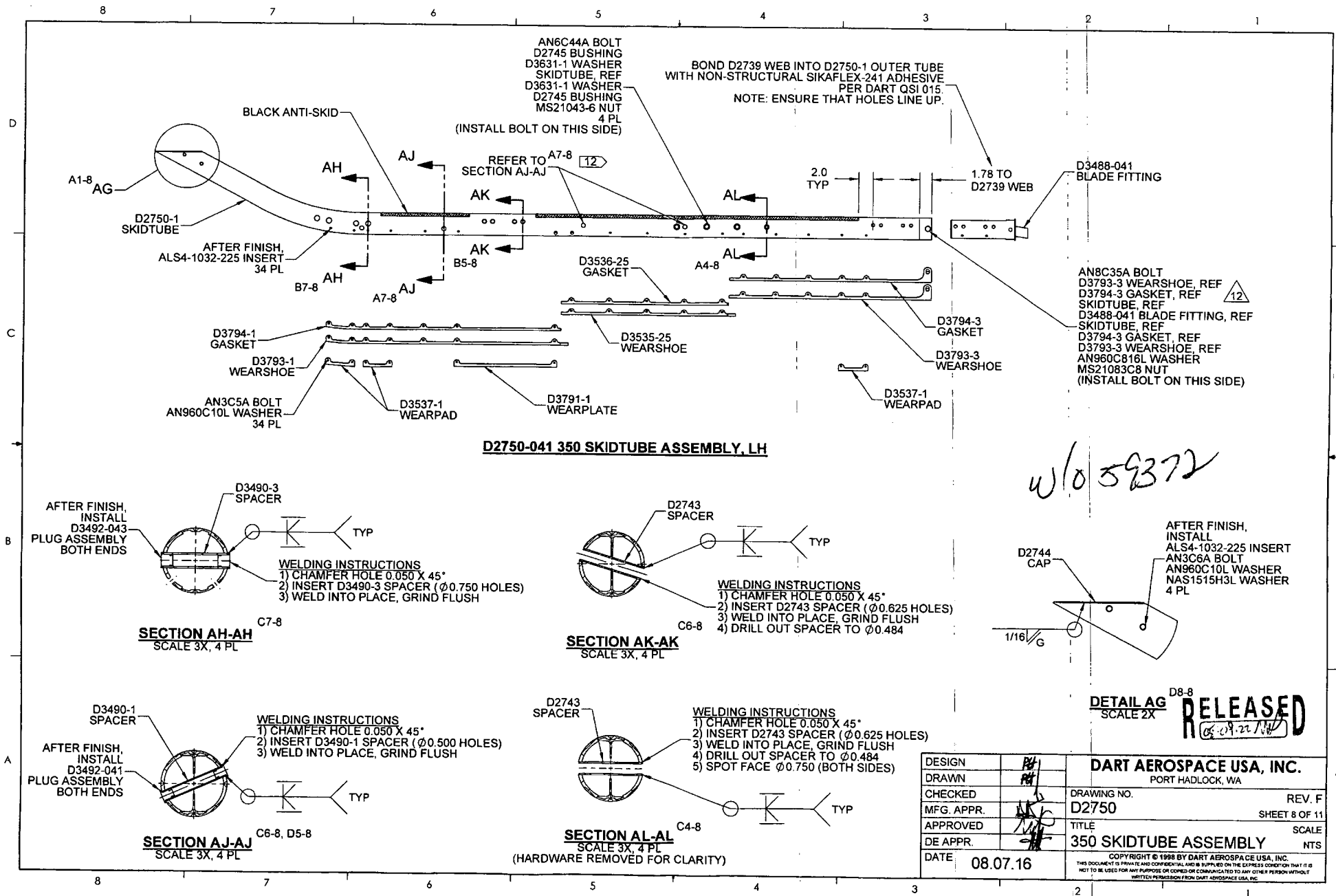
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NOTE: Date & initial all entries



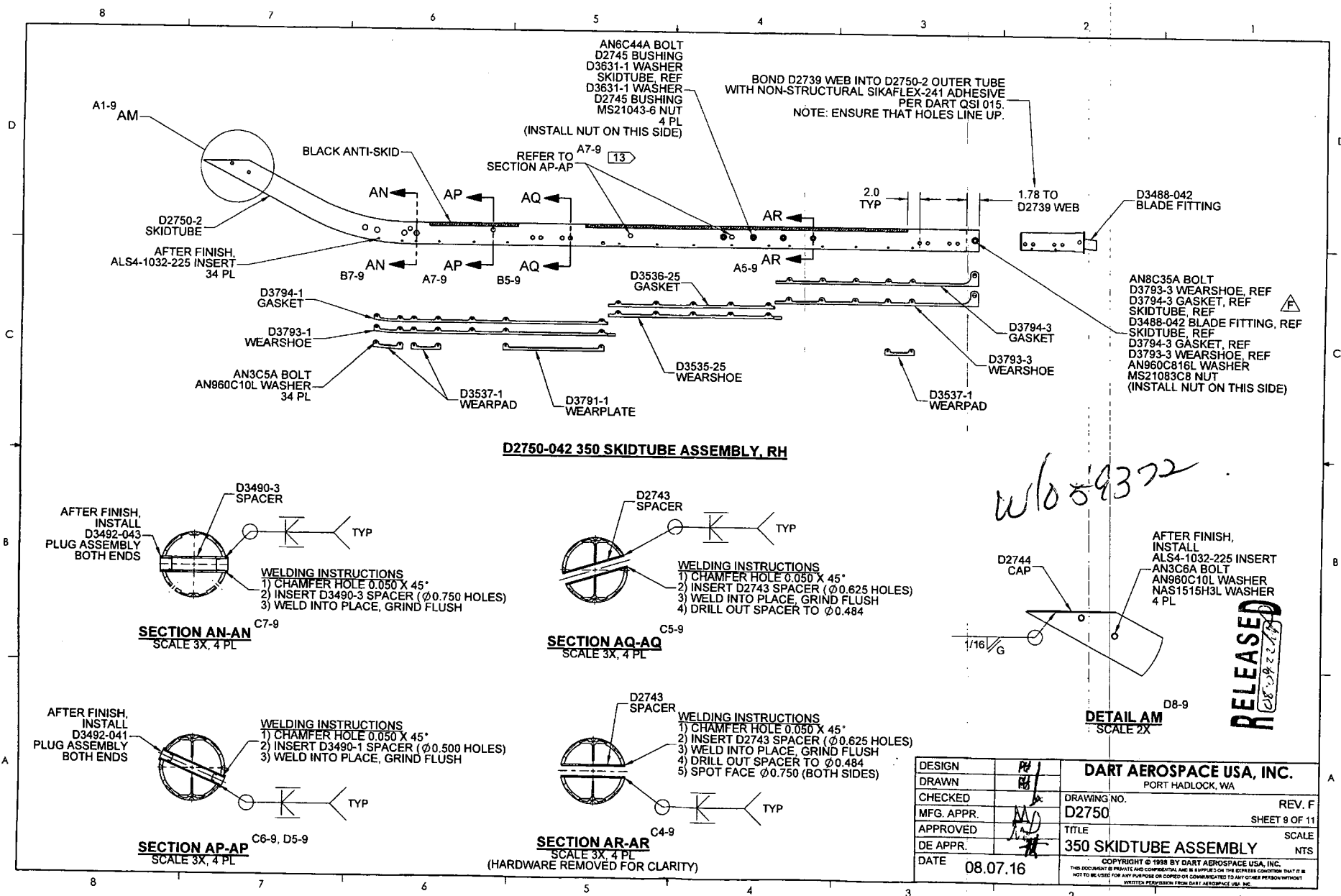
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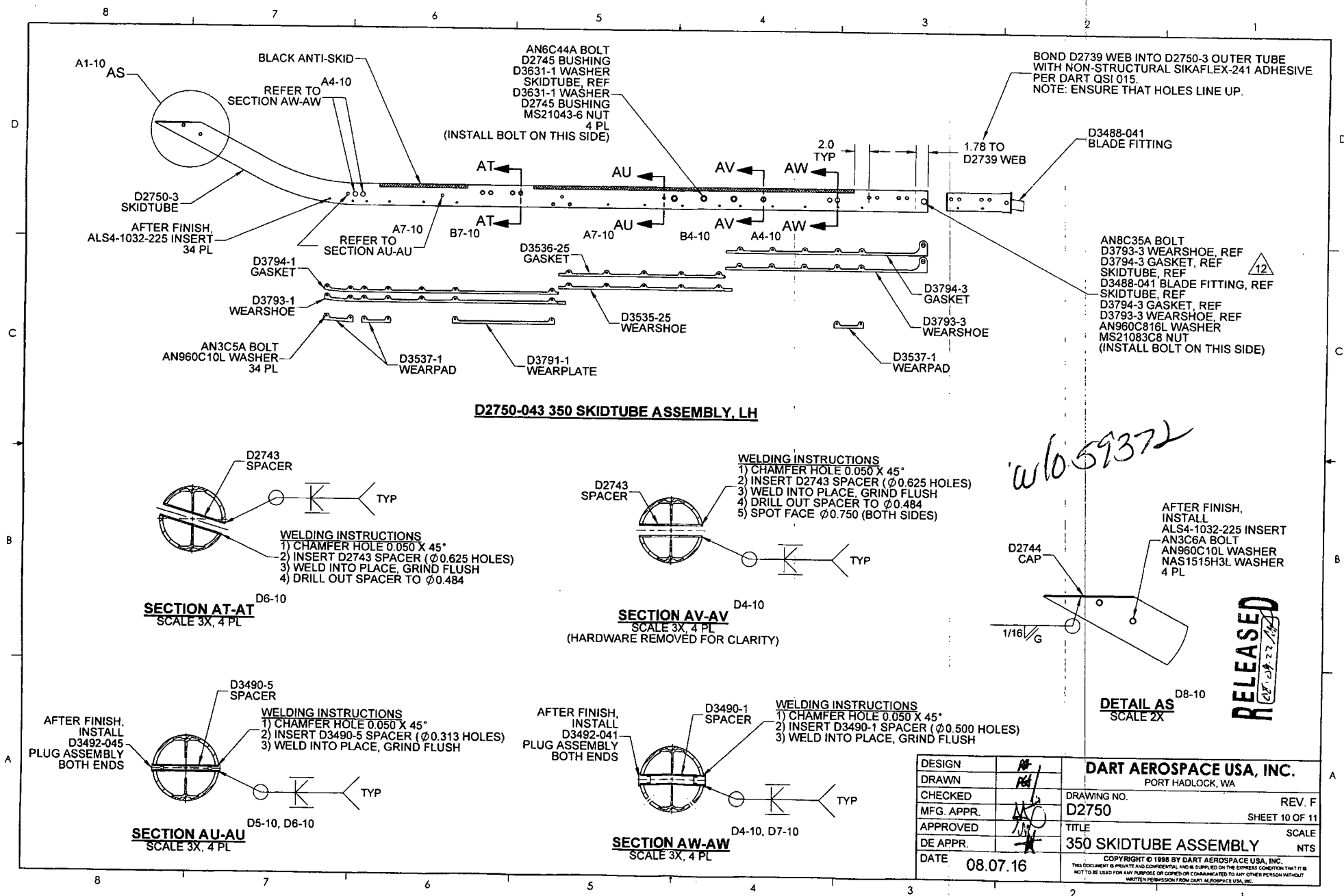
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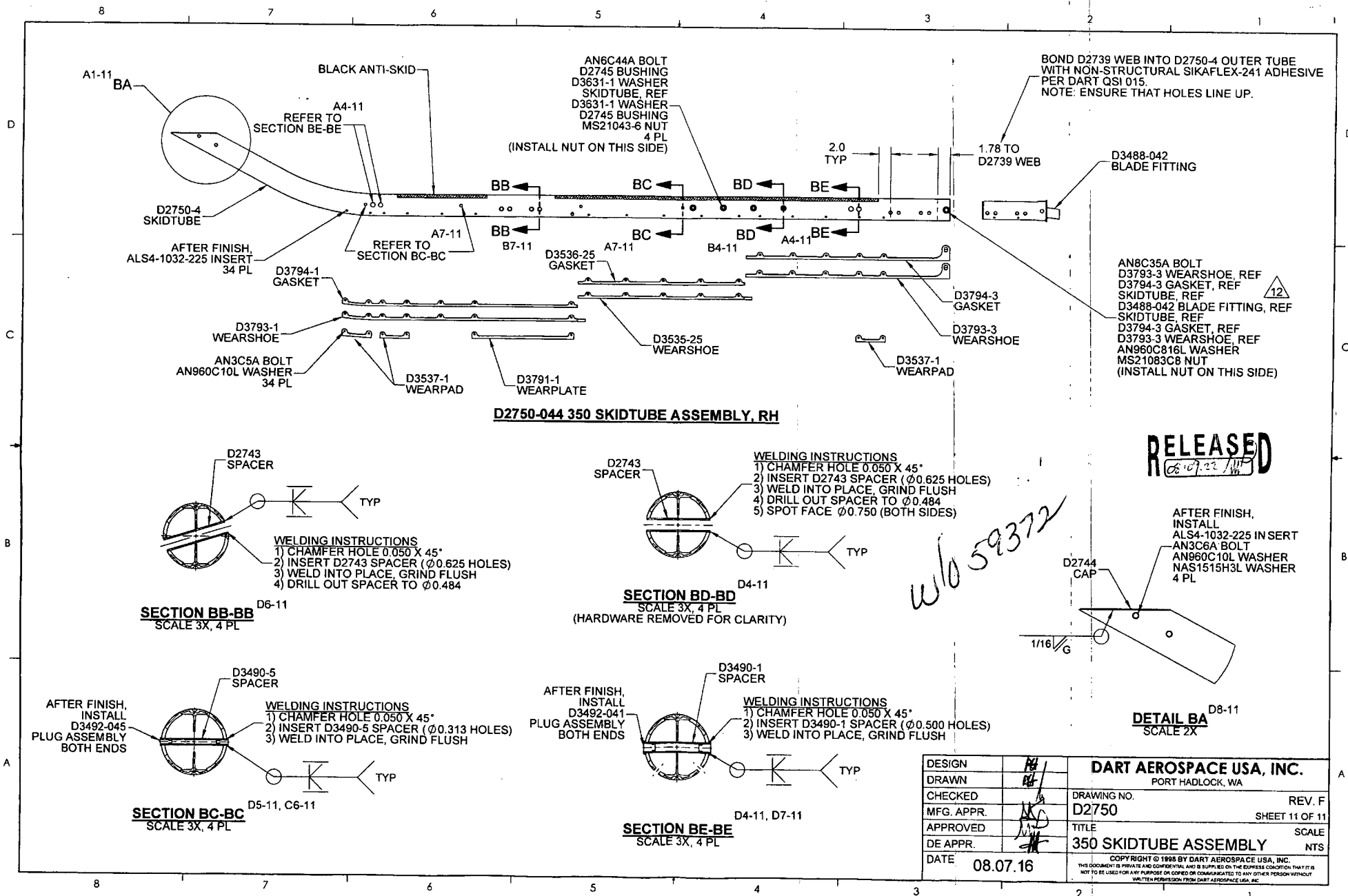
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 234

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 59818
Part number: D350-626-011
Description: 320 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

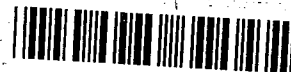
Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. D. A. Date of Test Coupon 10-06-21
Welder Barclay Elliott Date of Test Coupon 10-06-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 59372

Wednesday, June 02, 2010 1:19:55 PM



Page 1

Item ID: D350-636-012

Revision ID:

Accept

Item Name: Skidtube RH

Start Date: 6/2/2010 Start Qty: 1.00

Required Date: 6/9/2010 Req'd Qty: 1.00

Reference:



Cust Item ID:
Customer:



Setup Start

Stop



Approvals: Process Plan: *H*
QC:

Date: *10-6-02* Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100



DC

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